

**ABSTRACT**

An apparatus and method for forming a duct member having a plurality of adjustable sections which are rotatable relative to one another. The apparatus and method causes relative rotation between individual sections during the manufacturing process, to form a completed duct member in an automated process utilizing a rotating head assembly comprising a plurality of engagement members extendable radially outward of the rotating head body in an engagement position and retractable radially inward to a disengagement position. Accordingly, a 90 degree adjustable elbow can be produced in its 90 degree elbow configuration without requiring the machine operator to manually adjust the adjustable sections.